



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

3

D5067-012
Job Sheet 183897



Part No: D5067-012

Job Qty: 1 ea

Part Name: Basket Assembly, Heavy Duty Lid, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5067 REV.A IPP REV:A 18.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		10/12/18	0.00	0.00	Start Up Handfinish		HL 18-10-20
110	HandFinish	1 pcs		10/12/18	0.00	1.00	HandFinish4		HL 18-10-20
120	QC	1 pcs		10/12/18	0.00	0.00	QC5		OCT 30 2018 68
130	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-2		9-89
140	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		DAS

Part Op Descriptions: 110 - ASSEMBLE AS PER DWG (SEE NOTE 8) AND INSTALL PLACARD.

21 NOV 13 2018
9-89

Job BOM

006148

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	100-Start up Operation	5019014
AN3-11A	Bolt	4 Ea (4 ea)	100-Start up Operation	5098034
AN3-14A	Bolt	4 Ea (4 ea)	100-Start up Operation	5068652
AN3-16A	Bolt	2 Ea (2 ea)	100-Start up Operation	5089276
AN310-4	Nut	3 Ea (3 ea)	100-Start up Operation	5116953
AN310C4	Nut	3 Ea (3 ea)	100-Start up Operation	5065268
AN4-12	Bolt	3 Ea (3 ea)	100-Start up Operation	5115642
AN4-13A	Bolt	6 Ea (6 ea)	100-Start up Operation	5089302
AN4C15	BOLT	1 Ea (1 ea)	100-Start up Operation	5053946
AN5-17A	Bolt	4 Ea (4 ea)	100-Start up Operation	5068640
D2530	Handle Weldment	1 Ea (1 ea)	100-Start up Operation	5109659
D2535	Spring	2 Ea (2 ea)	100-Start up Operation	5073832
D2537	Bushing	2 Ea (2 ea)	100-Start up Operation	5115452
D2690-10	Lanyard Assembly	1 Ea (1 ea)	100-Start up Operation	5105786
D2690-6	Lanyard	1 Ea (1 ea)	100-Start up Operation	5115104
D3912-041	Eyebolt Receiver Assembly	1 Ea (1 ea)	100-Start up Operation	5122426
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	100-Start up Operation	5114790
D3917-3	Washer	6 Ea (6 ea)	100-Start up Operation	5115446
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	100-Start up Operation	5119290
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	100-Start up Operation	5068384
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	100-Start up Operation	5068380
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	100-Start up Operation	5117579
D3953-7	Spring Spacer	2 Ea (2 ea)	100-Start up Operation	5115826

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

D3953-9	Gas Spring Washer	2 Ea (2 ea)	100-Start up Operation	5115399
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	100-Start up Operation	5107870
D4150-041	Attachment Arm Assembly	1 Ea (1 ea)	100-Start up Operation	5118811
D4151-041	Basket Fwd Hardpoint Assembly, Lower	1 Ea (1 ea)	100-Start up Operation	5115042
D4151-043	Basket Fwd Hardpoint Assembly, Upper	1 Ea (1 ea)	100-Start up Operation	5095336
D4713-1	Spacer	1 Ea (1 ea)	100-Start up Operation	5121787
D5068-041	Long Basket Base Assembly, LH/RH	1 Ea (1 ea)	100-Start up Operation	5115816
D5533-200	Placard, Max Load	1 Ea (1 ea)	100-Start up Operation	F165831
D5554-1	Bracket	2 Ea (2 ea)	100-Start up Operation	5049423
MS17984-C412	Pin, Quick Release	1 Ea (1 ea)	100-Start up Operation	5096922
MS17984-C413	Quick Release Pin	1 pcs (1 ea)	100-Start up Operation	5090629
MS21042L3	Nut	10 Ea (10 ea)	100-Start up Operation	5094592
MS21042L4	Nut	6 Ea (6 ea)	100-Start up Operation	506789
MS21042L5	Nut	4 Ea (4 ea)	100-Start up Operation	5083541
MS24665-151	Cotter Pin	4 Ea (4 ea)	100-Start up Operation	50539513
MS24665-300	Cotter Pin	2 Ea (2 ea)	100-Start up Operation	5104465
MS3367-5-0	Tie Wrap	1 Ea (1 ea)	100-Start up Operation	5050161
NAS1149C0432R	Washer	2 Ea (2 ea)	100-Start up Operation	50500521
NAS1149C0463R	Washer	3 Ea (3 ea)	100-Start up Operation	F1127306-15
NAS1149F0332P	Washer	16 Ea (16 ea)	100-Start up Operation	5103666
NAS1149F0432P	Washer	18 Ea (18 ea)	100-Start up Operation	5683508
NAS1149F0563P	Washer	4 Ea (4 ea)	100-Start up Operation	5067901-2
NAS1515H4L	Washer	2 Ea (2 ea)	100-Start up Operation	5044189

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	97447A010	4	714	0
	AN3-11A	4	220	0
	AN3-14A	4	284	0
	AN3-16A	2	114	0
	AN310-4	3	106	0
	AN310C4	3	134	0
	AN4-12	3	89	0
	AN4-13A	6	650	0
	AN4C15	1	26	0
	AN5-17A	4	141	0
	D2530	1	14	0
	D2535	2	33	0
	D2537	2	4	0
	D2690-10	1	1	0
	D2690-6	1	36	0
	D3912-041	1	3	0
	D3914-041	1	8	0
	D3917-3	6	15	0
	D3953-17	2	15	0
	D3953-19	1	23	0
	D3953-21	1	29	0
	D3953-3	2	12	0
	D3953-7	2	14	0
	D3953-9	2	5	0
	D3969-3	1	15	0
	D4150-041	1	8	0
	D4151-041	1	3	0
	D4151-043	1	0	0
	D4713-1	1	35	0
	D5068-041	1	0	0
	D5533-200	1	7	0
	D5554-1	2	2	0
	MS17984-C412	1	15	0
	MS17984-C413	1	63	0
	MS21042L3	10	3,023	0
	MS21042L4	6	4,255	0
	MS21042L5	4	792	0
	MS24665-151	4	238	0
	MS24665-300	2	122	0
	MS3367-5-0	1	758	0
	NAS1149C0432R	2	2,617	0
	NAS1149C0463R	3	319	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

NAS1149F0332P	16	3,025	0
NAS1149F0432P	18	1,426	0
NAS1149F0563P	4	805	0
NAS1515H4L	2	209	0

Part Specifications

Specifications could not be found.



Container No: S122578



Part: D5067 - 012

Job No: 183897

Serial No/Batch: S122578

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/30/18

Plex 9/28/18 10:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



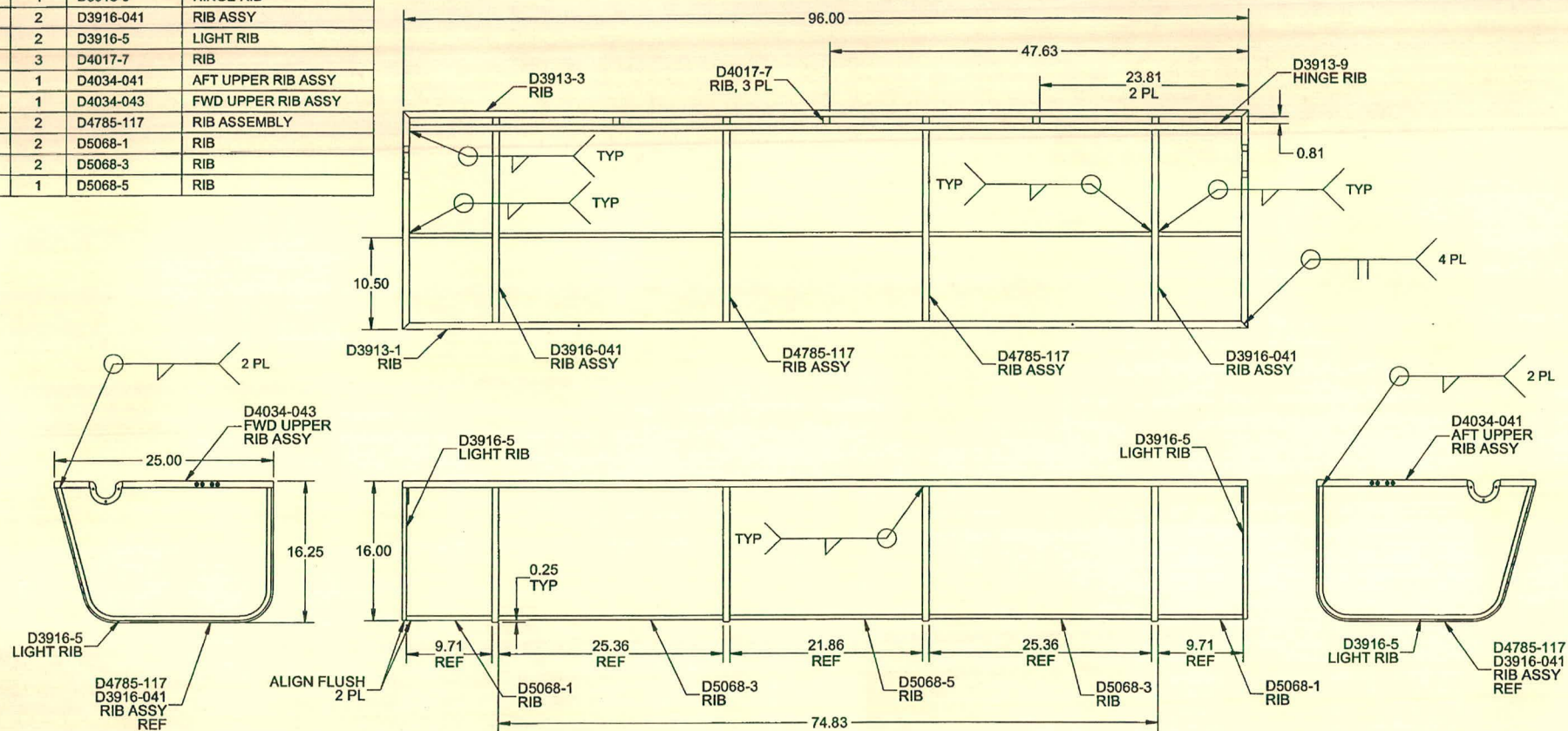
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

ITEM	QTY -101	P/N	DESCRIPTION
1	X	D5068-101	TUBULAR ASSEMBLY
2	1	D3913-1	RIB
3	1	D3913-3	RIB
4	1	D3913-9	HINGE RIB
5	2	D3916-041	RIB ASSY
6	2	D3916-5	LIGHT RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D4785-117	RIB ASSEMBLY
11	2	D5068-1	RIB
12	2	D5068-3	RIB
13	1	D5068-5	RIB



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 25.18 lbs
 - 8) WELD PER DART QSI 004

D5068-101 TUBULAR ASSEMBLY, LH/RH

RELEASED
2018-01-08

APPROVED

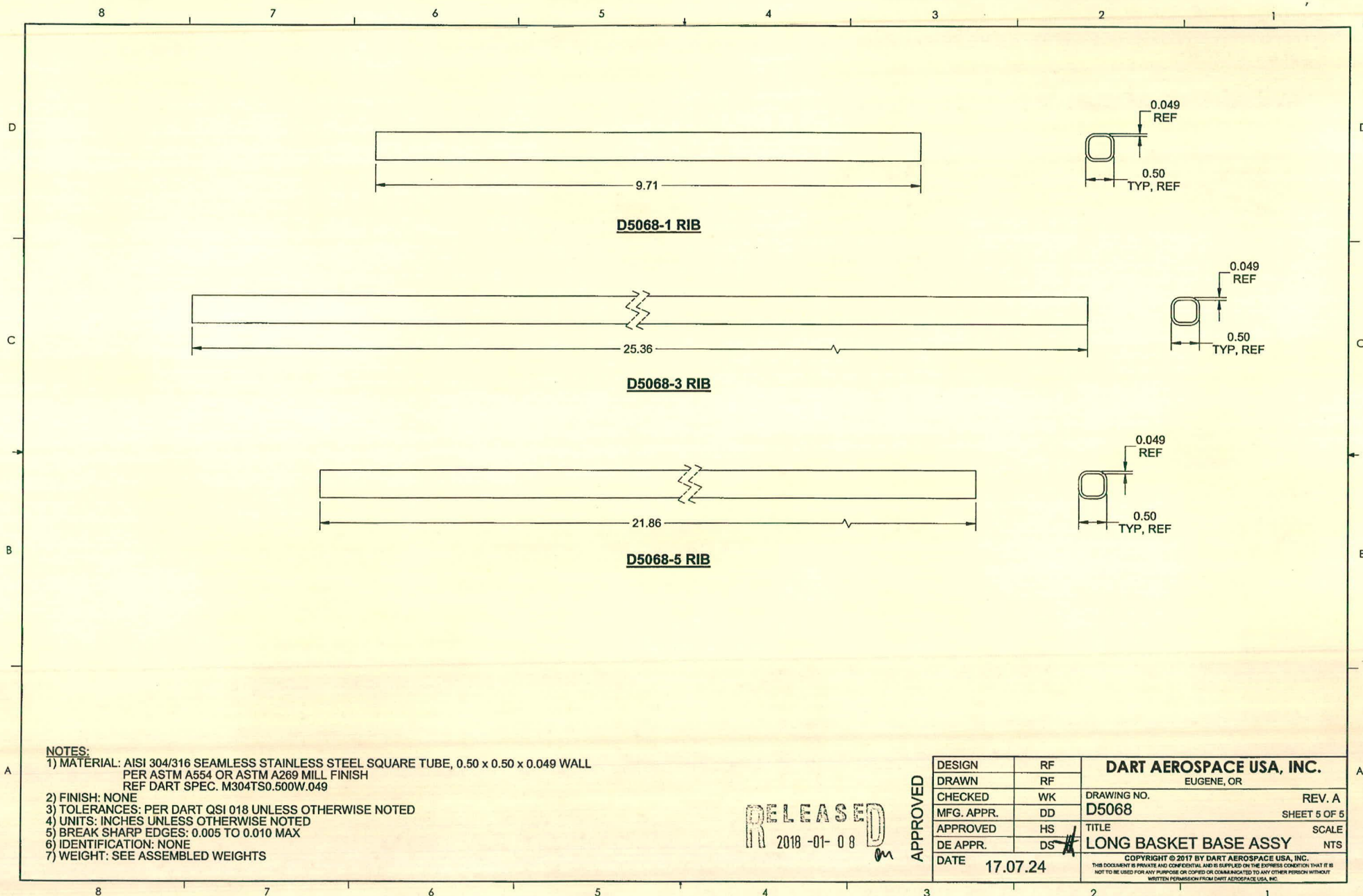
DESIGN	RF
DRAWN	RF
CHECKED	WK
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	17.07.24

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO.	REV. A
D5068	SHEET 4 OF 5
TITLE	SCALE
LONG BASKET BASE ASSY	NTS

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5067



NOTES:

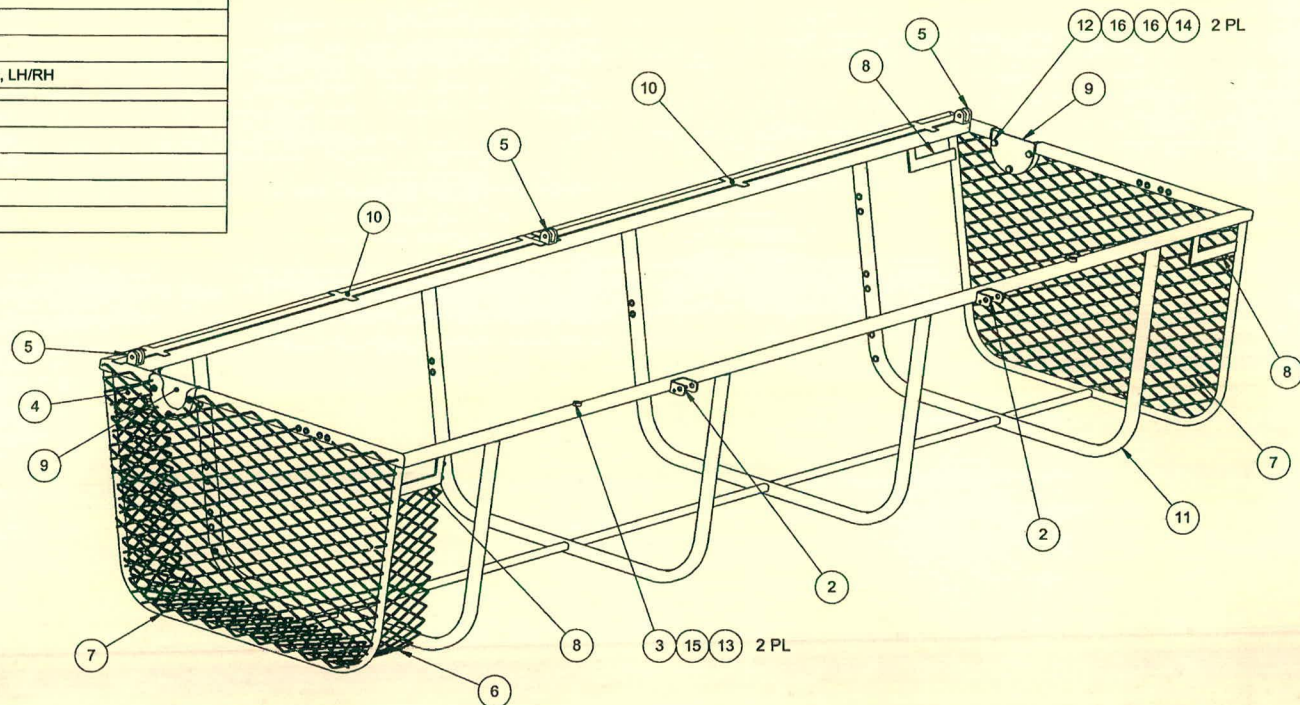
- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2018-01-08

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5068	REV. A SHEET 5 OF 5
MFG. APPR.	DD	TITLE LONG BASKET BASE ASSY	SCALE NTS
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DE APPR.	DS		
DATE	17.07.24		

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5068-041	LONG BASKET BASE ASSY LH/RH
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH BASKET LONG, BASE
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	1	D5068-101	TUBULAR ASSEMBLY, LH/RH
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER
16	12	NAS1149F0332P	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

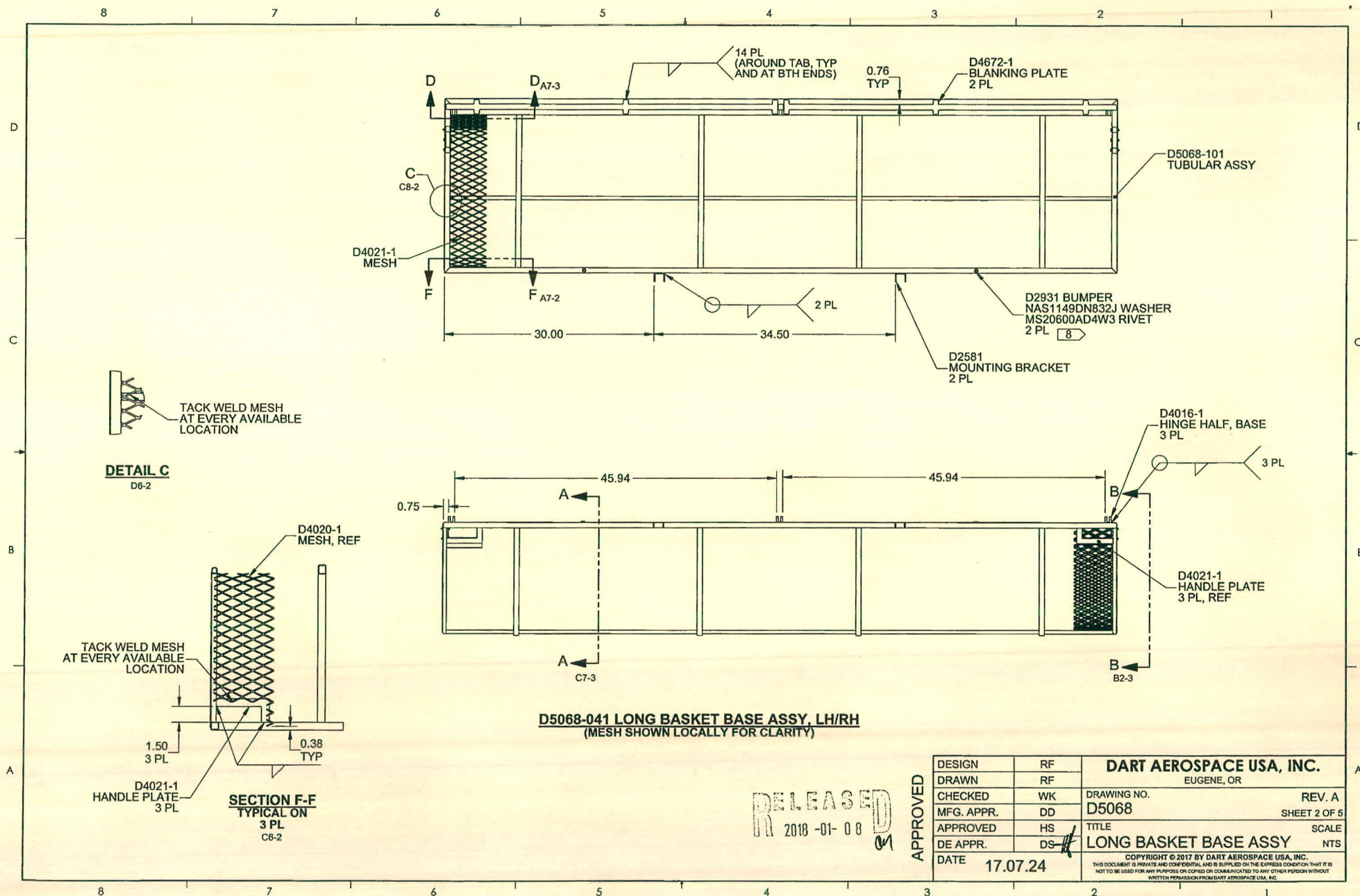
D5068-041 LONG BASKET BASE ASSY, LH/RH

RELEASED
2018-01-08
ECW17-793

APPROVED

A		NEW ISSUE		RF	17.07.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.			
DRAWN	RF	EUGENE, OR			
CHECKED	WK	DRAWING NO.	REV. A		
MFG. APPR.	DD	D5068	SHEET 1 OF 5		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	LONG BASKET BASE ASSY	NTS		
DATE	17.07.24				

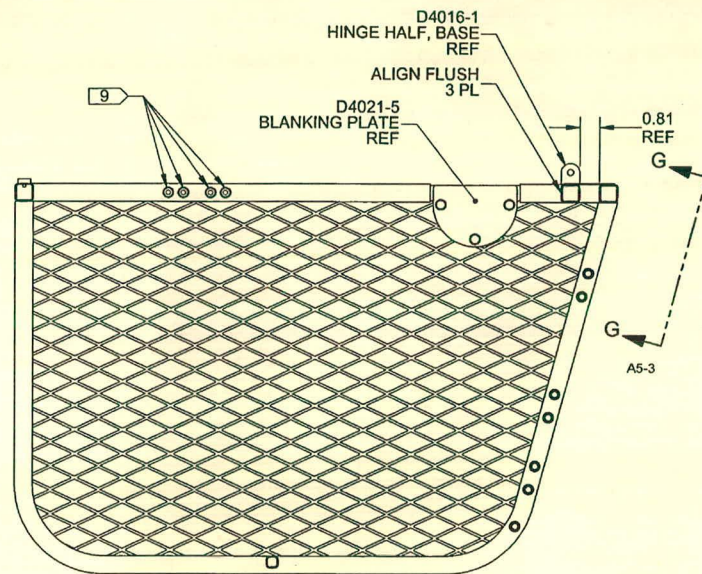
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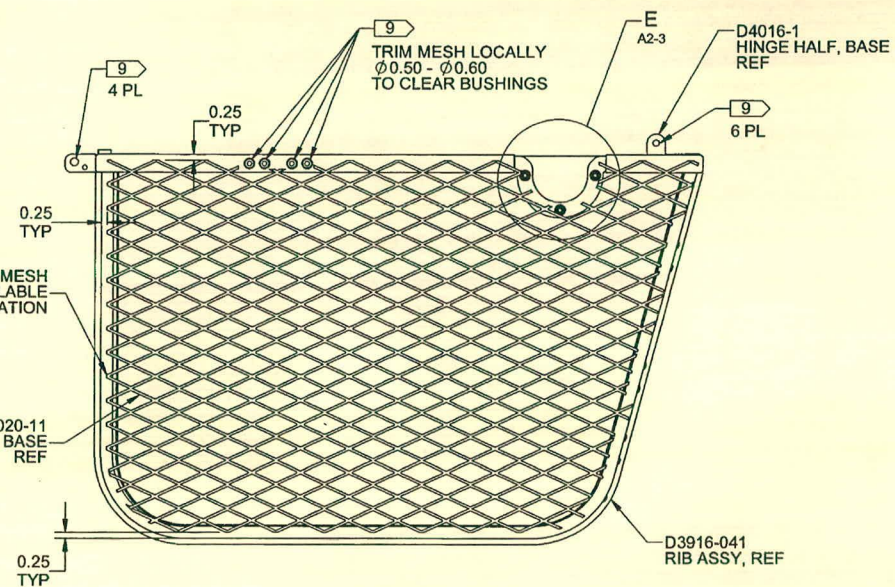
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2018-01-08

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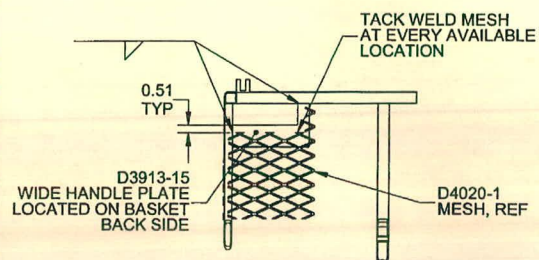
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CHECKED	WK	DRAWING NO.	REV. A
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APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY	NTS
DATE	17.07.24	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



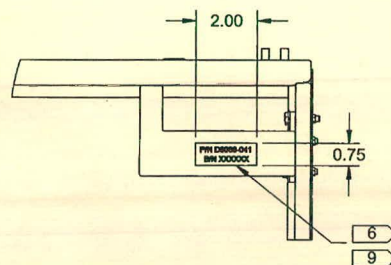
SECTION A-A
B6-2



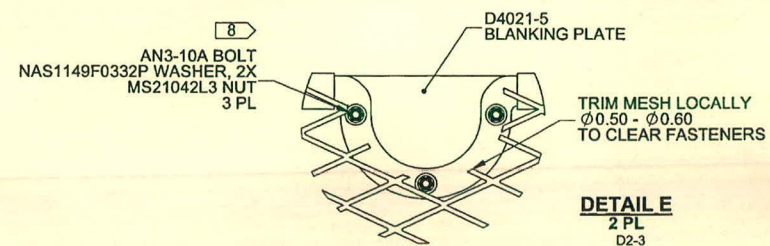
SECTION VIEW B-B B2-2



SECTION D-D
D6-2



DETAIL G
D5-3



DETAIL E
2 PL
D2-3

RELEASED
2018-01-08

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